

Work Order ID 149091

Tuesday, July 19, 2016 2:45:03 PM

149091

Page 1

Item ID: D4634-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Middle, Center Ceiling Panel
 Start Date: 7/12/2016 Start Qty: ~~4.00~~ ² ***X*** Cust Item ID:
 Required Date: 7/19/2016 Req'd Qty: ~~4.00~~ ² ***X*** Customer:
 Reference:

Approvals: Process Plan: DAS 21 Date: JUL 20 2016 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<u>Draw Nbr</u>	<u>Revision Nbr</u>								
D4634	G					DAS			Pto
100		0.00				07			
100	HAND FINISHING THERMOFORMING					9-89			
Thermoform	Memo	0.11				2			16/07/28
Thermoforming Machine	Cut Blanks								
105		0.00				DAS			
105	Dry Material					07			
HandThermo	Memo	0.00				9-89			
Hand Finishing Thermoforming	Dry Sheet as per QSI022 POLYCARBONATE					2			16/07/28
	Temp: 245 deg. F								
	Time IN: 5:00 PM								
	Time OUT: 6:00 AM								
	JUL 27 2016								
	Per.....								

DQA:

Date:

16.08.29



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

16.08.17

Work Order update only ☐

Work Order: <u>149091</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. <u>04634-3</u>		Rework ☒		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐		
NCR No. <u>16-5983</u>		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☒	Quality ☐		
		Use-as-is ☐		Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐		
		Suspected Unapproved ☐		Large Fab ☐	Composite ☐	Supplier ☐			
Date: <u>16/08/17</u>		Step #: <u>100</u>		QTY Effective:			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition			DAS 16 9-89 <u>16/08/17</u>		
FAB NOT SAME REV as w/o.				UPDATE REV on FAB sheet Per same as Day + w/o.			Completed By 10 9-89 <u>16-08-17</u>		
							Lead hand / Supervisor Approval Verification 15 DAS 07 9-89		
							QC / QA Coordinator Approval DAS 16 9-89 <u>16/08/17</u>		
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☒	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☒	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER:							

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : _____									

1 49091

Tuesday, July 19, 2016 2:45:03 PM

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 7/12/2016 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 7/19/2016 **Req'd Qty:** 4.00 ***1***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

~~QC6- Inspect dimensions to drawing~~

0.00

140

Dimensional Inspection

0.00

QC

Memo

Quality Control

Fill out Inspection Sheet Rev. A

~~Q25- Inspect part completeness to step on W/O~~

0.00

150

Memo

0.01

QC

Quality Control

Packaging

0.00

160

Memo

0.00

Packaging

Packaging

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☒

Work Order: <u>149091</u> Part No. <u>DH634-3</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: <u>16/02/12</u>		Step #: _____		QTY Effective: _____			MRB (QSI042) Approval D: DAS 1 16 9-11/12 9-89		
Description Work Order Deviation				Disposition				Completed By	
Change steps # 140 & 150 to Qc2 & Qc3								10 DAS	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER: _____									

Work Order ID 149091

Tuesday, July 19, 2016 2:45:03 PM

149091

Page 4

Item ID: D4634-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Middle, Center Ceiling Panel

Start Date: 7/12/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/19/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
Qty
DAS
21
9-89Reject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.07

Quality Control

AUG 15 2016DAS
21
9-89**AUG 15 2016**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
		OTHER : _____							

Picklist Print

Tuesday, July 19, 2016 2:45:02 PM

Page 1

Work Order ID: 149091

149091

Parent Item: D4634-3

D4634-3

Parent Item Name: Middle, Center Ceiling Panel

Start Date: 7/12/2016

Required Date: 7/19/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev. A 12/08/09 New Issue DL
12/11/08 Document release DL VERIFIED BY:JLM
Dwg Update DL verf: DD
DL
DL
DL
IPP Rev B
IPP Rev C 13/07/09
IPP Rev D Dwg Update 13/12/23
IPP REV E Dwg update 14/01/09
IPP Rev F Dwg. update 14/02/03
IPP Rev G Dwg. Update 15/01/27 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	380.9000	17.33	69.32			DAS 07 9-89
MI FXS 093-F6006-07									**				
GE PLASTICS LEXAN SHEET (Grey)													

Location

Loc Qty

Loc Code

MAT023

380.9

m129738

380.9

35 sq ft.

16/08/13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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OTHER :																																																																									

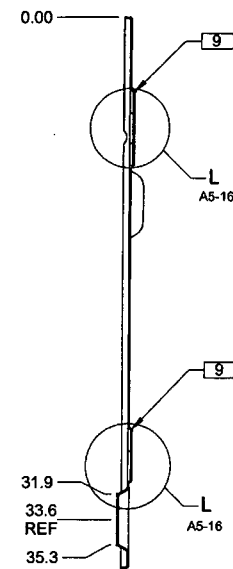
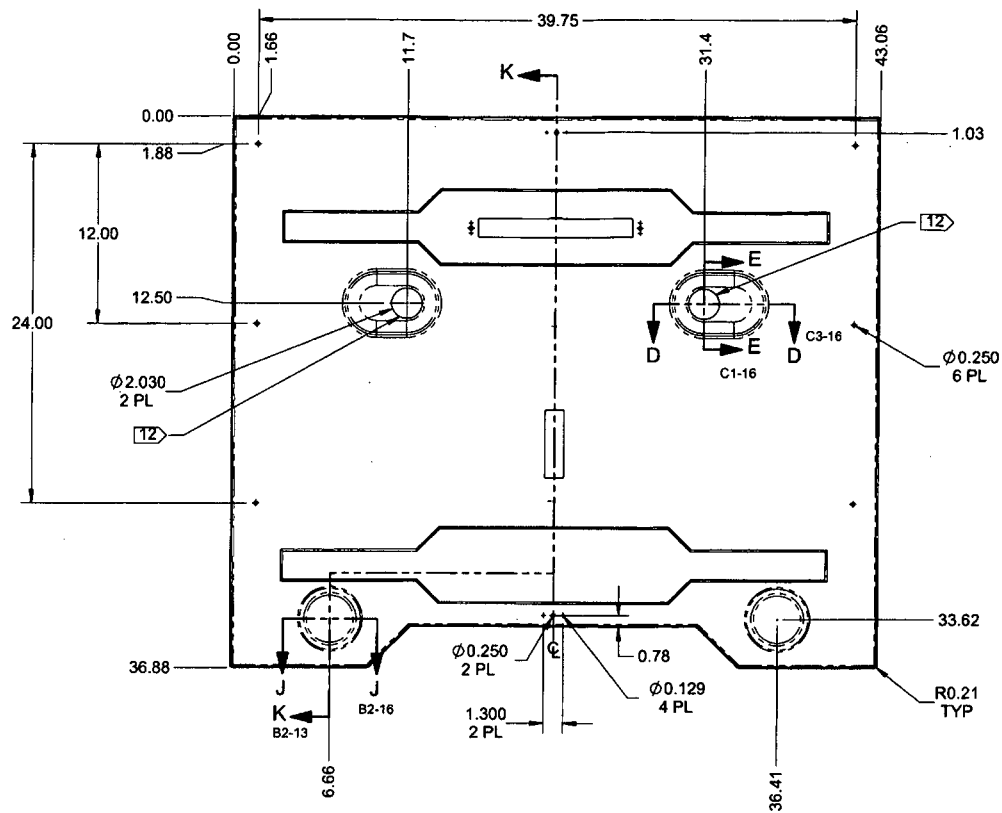
DART AEROSPACE LTD		Work Order: 149 091
Description: Middle Center Ceiling Panel		Part Number: D4634-3
Inspection Dwg: D4634	Rev: E 7 8 16/08/12	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
15.91	+/-0.030	15.91	✓		T.M	
10.20 10.25	+/-0.030	10.28	✓		T.M	
11.25	+/-0.030	11.25	✓		T.M	
1.25	+/-0.030	1.25	✓		CD-6	
4.55	+/-0.030	4.556	✓		CD-6	
1.25	+/-0.030	1.75	✓		CD-6	
21.53	+/-0.030	21.53	✓		T.M	
24.00	+/-0.030	24.00	✓		T.M	
12.00	+/-0.030	12.00	✓		T.M	
39.75	+/-0.030	39.75	✓		T.M	
1.300	+/-0.010	1.301	✓		CD-6	
Ø0.250	+0.005/-0.001	0.250	✓		CD-6	
Ø0.129	+0.005/-0.001	0.129	✓		CD-6	
Ø0.250	+0.005/-0.001	0.250	✓		CD-6	
Ø2.030	+0.012/-0.001	2.035	✓		CD-6	
Ø0.250	+0.005/-0.001	0.250	✓		CD-6	
0.688	+/-0.030	0.688	✓		CD-6	
Ø0.098	+0.004/-0.001	0.098	✓		CD-6	
0.344	+/-0.010	0.350	✓		CD-6	
0.50	+/-0.030	0.525	✓		CD-6	
3.50	+/-0.030	3.521	✓		T.M	
8.00	+/-0.030	8.015	✓		T.M	

Measured by: DAS	Audited by: S.M.B	Preliminary Approval:
Date: 16/08/12	Date: 16/08/12	Date:

Rev	Date	Change	Revised by	Approved
A	14.07.29	New Issue	KJ	



D4634-3 MIDDLE, CENTER CEILING PANEL
AUXILIARY VIEW

SECTION K-K B6-13

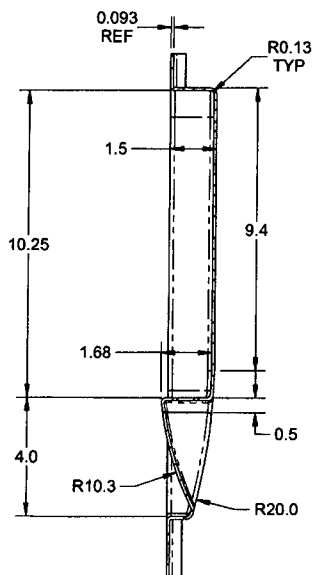
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2015 JAN 26 *ap*

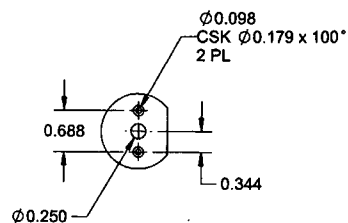
APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	DL	D4634	SHEET 13 OF 17
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CENTER CEILING PANELS	NTS
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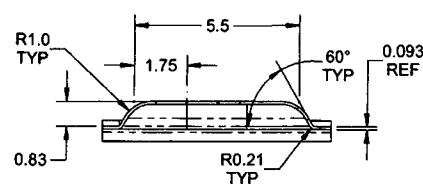
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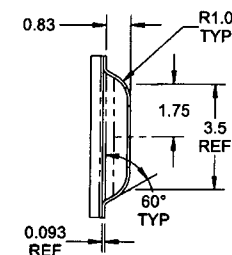
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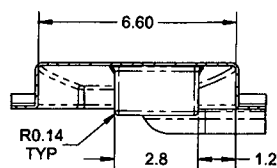
DETAIL C B7-10
SCALE 4X B4-12
B4-14



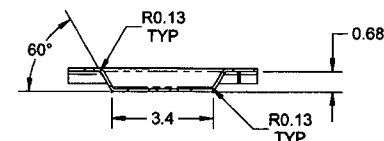
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C4-15



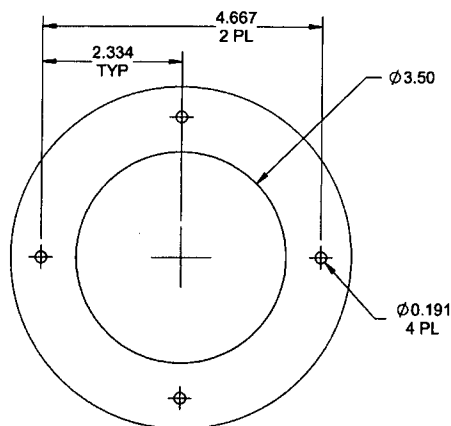
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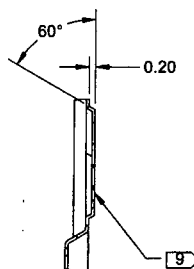
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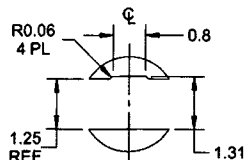
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DETAIL B B7-10
SCALE 4X
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DETAIL I B2-13
SCALE 4X C2-13
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C2-14



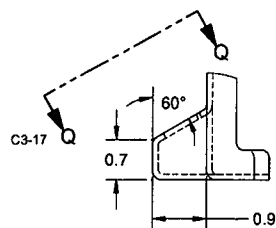
DETAIL V C4-10
SCALE 2X B4-12
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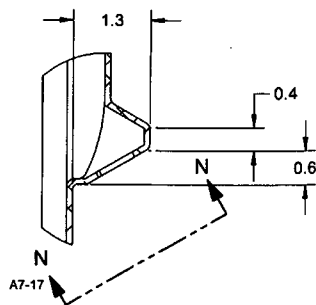
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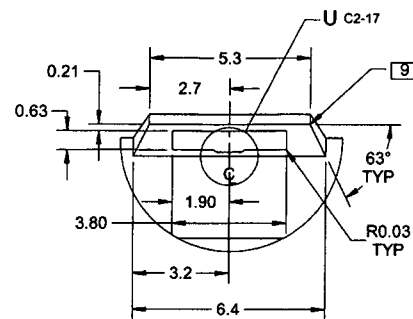
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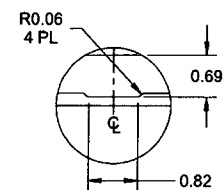
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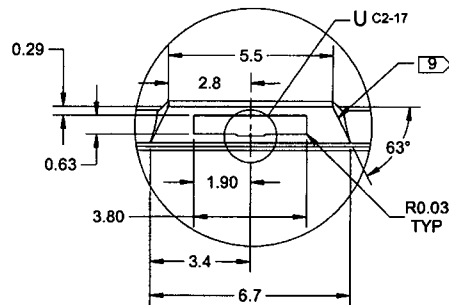
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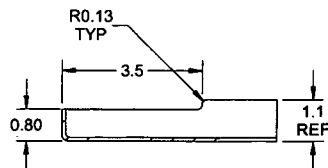
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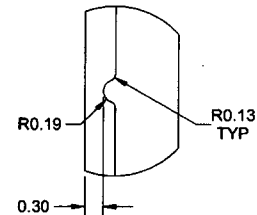
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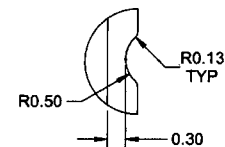
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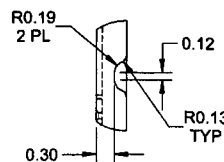
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SCALE 1.3X



DETAIL R B3-10
SCALE 4X



DETAIL S B3-10
SCALE 4X



DETAIL T C2-14
SCALE 4X

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